Work Orde		8274			*982	74*							Page 1
Revision ID:	D2022-103 Spacer		, D	4	Accept	*N900	040	100)* :	Setup S	Start Stop	*N:	S1*
	3/11/13	Start Qty: 24	1.00	*24* *24*		Cust Item II Customer:	D:					IV.	
Approvals:	Process P	lan: <u>Mし</u> ろ	Dat	e: 13-103-15	Tooling:	Da	ite:		Ì		Start	*N	R1*
	QC:			e:		Da	ite:			1	Stop	*N	R2*
Sequence ID/ Work Center II	D	Operation Description			Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp
Draw Nbr	Re	evision Nbr											
D2022	Re	ev	;										
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100 Hardinge Hardinge CNC Lath	e Small	1-Tur FOLI DWG	o 323" dia drill n as per folio F D REV:	<u> </u>	0.00	JJ 1.	3-03-7	7	<u>60</u>	<i>,6</i>	ν 		
110		QC2- Inspect part	s off machine I	FAI/FAIB	0.00								
110 QC Quality Control		Mem	0		0.00	<i>S</i> J13	1-03-2	7	60	<i>b</i>	2		

										DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON	-CON	IFORM	MANCE / UPDATE		QA Closed:	Date:	·
Work Orde	er:				DISPOSITION			AGAI	NST DE	PARTMENT	/PROCESS	
	lo				Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstu Machining Small F Thermoforming Finishi Large Fab Composi			1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descr	iption of work order update		nitial	Action		Sign &		
Cause	Date	Step	Qty	·	or Non-conformance	Chi	ief Eng	Description		Date	Verification	QC Inspector
Doc/Data Equip/Tooling											,	
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Landir	ng Gear			_	General		C			Ovalized	_	Pressure/Forced
	Bending	- . C		o/s -	Bend BOM/Route		Grain Hardwa	***	-	Over/Under	tolerance	Temperature/Cure
	Centre N	ot Conce	ntric to i	^{0/3} -	Broken/Damaged			ion Incomplete	\vdash	Part Incorre	 	Weld
	Cracks Crushed/	'Crimpad		-	Burrs		,	tions Incomplete/Unclear	-	Part Lost/M	<u> </u>	Wrong Stock Pulled
<u> </u>	Cuffs	cimpeu.	•	-	Contamination	<u> </u>	Mainte	•		Part Moved	_	
; }	Heat Treat		Countersink	\vdash	Mislabe			Positioned \				
<u> </u>	Inspectio		Tube	F	Cut Too Short	-	Misread			Power Loss,		Other
<u> </u>	Ripples in				Drill Holes	\vdash	Offset		L.—	⊿ ′	<u>-</u>	, t
<u> </u>			Extrusio	, -	Drawing Out of Calibration			Calibration				
 	Torque Waves in Extrusion Turning Sequence			Finish		Out of S	Sequence					

Outside Dimensions

Wave/Twist in Tube

Folio

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Work Ord March-12-13 1		274			Page 2							
Item ID: Revision ID: Item Name:	D2022-103 Spacer			Accept		*N900	040	100)* s	etup Stai	IV	S1* S2*
Start Date: Required Date Reference:	3/11/13 : 3/18/13	Start Qty: 24.00 Req'd Qty: 24.00	*74* *74*	,		Cust Item I Customer:	D:		ę	2		
Approvals:	Process Pla	ın:	Date:	Tooling:			nte: nte:		ę R	kun Sta Sto	n IV	R1* R2*
Sequence ID/ Work Center I 120 *120* QC Quality Control	D	Operation Description QC8- Inspect parts - secon	nd check	Set U Run I 0.00	Hours	Tool ID / 3-3 -	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Packaging Packaging		Identify as per dwg & Stoo	ck Location: <u>ST00</u> 4	0.00					60			13-03-27 42
140 *140* QC Quality Control		QC21- Final Inspection - Memo	Work Order Release	0.00	·				<u></u>	13	3/3/2 MU	8 13-03-28

											DQA:	Date	:
NCR:	Yes	/ No		٠		WORK ORDER NON-C	CON	IFORI	MANCE / UP	DATE	0461	Data	
											QA Closed:	Date	· ·
Work Orde	or.					DISPOSITION	i			AGAINST DE	PARTMENT	PROCESS	
VVOIK OTU	er. -					Rework	1 		Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	Nο					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
, ,,,,,	-					Use-as-is	1 1		noforming	Finishing	4	e/Packaging	Other
NCR I	No.					Work Order Update	1		Large Fab	Composite	•	Supplier	1
											.		
Root					Descri	ption of work order update	I	nitial	Act	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling	Ш												
Operator	Ш												
Material	Ц												
Setup	Ш												
Other	Ш	•											
Process													
Supplier	Ш												
Training	Ш												
Unapproved													
							AUL	T CATE	GORY				
Landi	$\overline{}$				_	General		1		_	7	_	–
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*	\mathbf{I}	nspection		Tube	<u> </u>	Cut Too Short	_	Misread	d		Power Loss/	Surge	Other
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	_	Torque W			n	Drawing	\vdash		Calibration			71.0	
	\vdash	Turning S	-		· L	Finish	\vdash		Sequence				
	۱ ۱	Wave/Tw	ist in Tul	oe e	1	Folio	Outside Dimensions						

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Picklist Print

March-12-13 1:45:23 PM

Work Order ID:

98274

Parent Item:

D2022-103

Parent Item Name:

Spacer

Start Date: 3/11/13

Required Date: 3/18/13

Page 1

Start Qty: 24.00

Required Qty: 24.00

Comments:

IPP REV:A 11.05.11 new DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750 6061-T6 Round Bar .750"		Purchased	No			100	f	98.6290	0.0189	0.4774728 2.037	~ ·	<i>\$1</i> 13	-03-27
				<u>Location</u>		Loc Qty	<u>Lo</u>	c Code					
				MAT012		13							
				120	0734	13							
				MAT013		85.629							
				121	1282	9.024							

122081 123757

124681

26.494

0.869 49.242

											DQA	۸:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-O	100	NFORN	/ANCE / UP	DATE			<u>.</u>	
											QA Close	d:	n Date:	
Work Orde	or:					DISPOSITION				AGAINST DE	PARTMEN	T/PRO	CESS	
VVOIK OIG	ei. -					Rework	1		Skid-tube	Crosstube	1	Wa	ater Jet	Engineering
Part N	۷o					Scrap		١	Machining	Small Fab	Pi	rod. Eng	g. Coor.	Quality
						Use-as-is	-		noforming	Finishing	4		kaging	Other
NCR I	No					Work Order Update	_		Large Fab	Composite]	5	upplier	
Root					Descri	ption of work order update		Initial	Ac	tion	Sign &			
Cause		Date	Step	Qty	C	or Non-conformance	Ch	nief Eng	Desc	ription	Date	Vei	rification	QC Inspector
Doc/Data	Ш		:											
Equip/Tooling	Ш													
Operator														
Material	Ш						l							
Setup	Ш											-		
Other												1		
Process												İ		
Supplier														
Training							1	ļ						
Unapproved	П													
						F.	ΑUI	T CATE	GORY	_				
Landi	ng G	ear				General		_			_			_
		Bending				Bend		Grain			Ovalized			Pressure/Forced
		Centre No	ot Concer	ntric to (o/s	BOM/Route		Hardwa	re		Over/Und	er tolera	nce	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incor	rect		Weld
		Crushed/	Crimped.			Burrs		Instructi	ions Incomplete/	'Unclear	Part Lost/	Missing		Wrong Stock Pulled
		Cuffs				Contamination]Mainte	nance		Part Move	ed		
		Heat Trea	t			Countersink		Mislabe	le d	:	Positione	d Wrong		<u>_</u>
		nspection	n Strip in	Tube		Cut Too Short		Misread	l		Power Los	ss/Surge		Other
		Ripples in	Bend			Drill Holes		Offset						

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

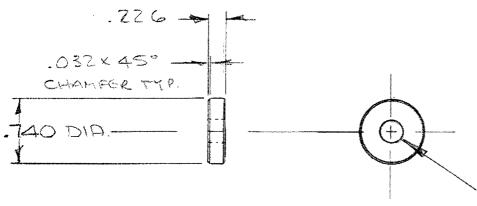
DART AEROSPACE LTD	Work Order: 98274	
Description: Spacer	Part Number: D2022-103	
Inspection Dwg: D2022 Rev:	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype											
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Con	nments				
0.740	+/-0.010	°738			5108	Veer	7				
0.032 x 45°	+/-0.05°	.028	/		(
0.226	+/-0.010	. 725	1								
Ø0.323	+0.006/-0.001	.028			V						
						 					
	- ff	Andian In-	1		Dundadama A.		NI/A				
leasured by:	13-03-27	Audited by:	17-3-	25	Prototype Ap	Date:	N/A N/A				

	-		<u> </u>		
Measured by:	St	Audited by:		Prototype Approval:	N/A
Date:	13-03-27	Date: []	-3-27	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	06.07.07	New Issue	KJ/JLM	B
			- ()	



ENCINCIA ENCINCIA SUBJECT 1 WORK OK!! NO _98274 MLD 13-03-15

D 20 2 2 - 10 1

DRILL F (.383) DIA IN -101 DRILL P (.383) DIA IN -103

MAT'L: ALUMINUM 6061-T6 (00-D-225/8)

	y, 40					D5055-10				ACUM 6061-76 ACUM 6061-76	8/025-4-00
	REVISION			RIVET CODE SHALL BE PER NAS 523	OTY, REQUIRED	PARTNO.	ITEM	DE	SCRIPTION .	MATERIAL	SPEC_/VENDOR
	DRAWN	THIS DRAWING IS PRIVATE AND CONFIDENTIAL A IT IS NOT TO BE USED FOR ANY PURPOSE OR CO WITHOUT THE PERMISSION OF CANT ARRO.	HO IS SUPPLIED ON THE EXPRESS COMMITTHAT DIED OR COMMITMICATED TO MITY OTHER PERSON	DIA DASH NO BASIC CODE NAMEAD NEAR SIDE	APPROVAL	CONTRACT NO.			ים גרו	T AERO ACCESSO	DIEC INC
	APPROVEO			F=HEAD FAR SIDE		DAUN		DATE	DAK	I HENO ACCESSO	KIES INC
2	1.	REQUIREMENTS — UNLE	SS OTHERWISE SPECIFIED	D-DMPLE DIGIT-NO OF SHEETS LENGTH DASH NO.		5500rs	<u>۲</u> .		CLENT		
200000	DESCRIPTION	1. DIMPERISIONS ARE IN MICHES	1. TOLERANCES - ICI ± 030	C-COUNTERSAIR W-SPOTWELD		OLENCE Sulpholimic	Y A	go-			
00000000000000000000000000000000000000	CHANGE	2 SUFFICE ROLCOMESS 73- 2 REMOVE SIGNETEDGES 016 MAX 4 THEADS PER MIX - 5 - 7742 5 HOLES PER AND 10387	JOCK 1,010 7 AMOLES 1 19" 2 PAPALLEUSM X DO25 4 ECCENTRICITY JOS MAX.	83-N570470MD 88-M520476A0		STRESS			TITLE	SPACES	52
*	•		. ALL M/C CENTINE LINES DOS			CLEAT			CODE	D202	2 80.
		REPORT	ALL DISCREPANCIES — DO NO)T SCALE						scut / ; / SHI	\ Of \

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